

DRAFT GREEN

Dart Aerospace Ltd.

Date: Thursday, 20/11/2008 11:43:07 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 43567					
Estimate Number	: 10534					
P.O. Number	:			Part Number	: D2574	
This Issue	20/11/2008	S.O. No.	:	Drawing Number	: D2574 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	11	Type	MACHINED PARTS	Drawing Revision	: E	
Previous Run	: 42805			Material	:	
Written By	:			Due Date	: 04/12/2008	
Checked & Approved By	: <u>JL 08.11.20</u>			Qty:	4	
Comment	: Est Rev: I As Per RevE 06-01-27 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B34874</u> <u>DTP 08/12/03</u> (6)	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>43567</u> Double check by: <u>J.E.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <u>DTP 08/12/07</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>DTP 08/12/07</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 7:20:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 43567

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/12/08

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



(6x)

7.0 POWDER COATING POWDER COATING



M 104476



(6x)

Comment: POWDER COATING

OLIVE DRAB GREEN

m-f 08/12/08

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



08 - 12 - 08 (6x)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



(6x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 425

8/12/08

SL 08/12/09 (6x)

10.0 QC21 FINAL INSPECTION/W/O RELEASE

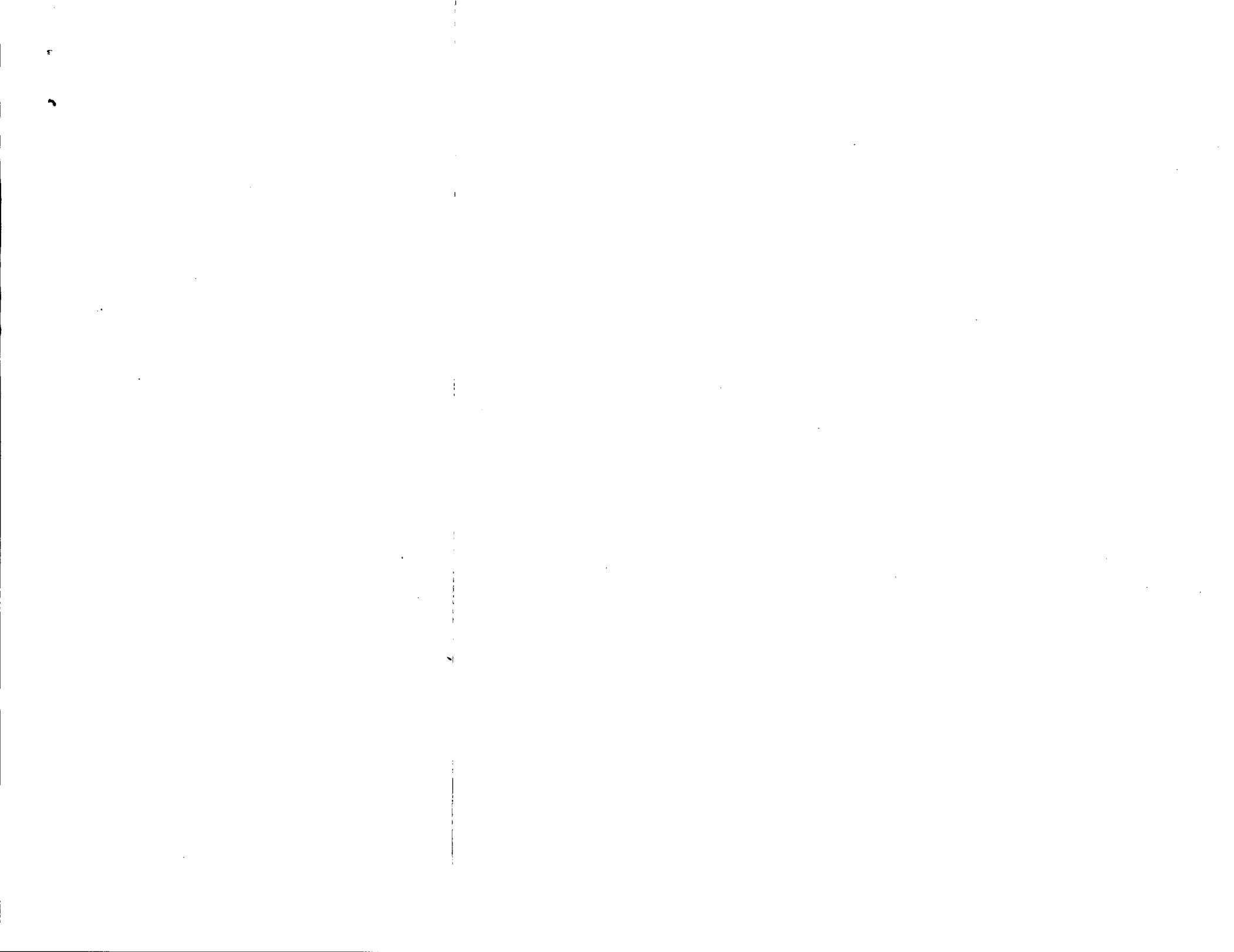


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-08



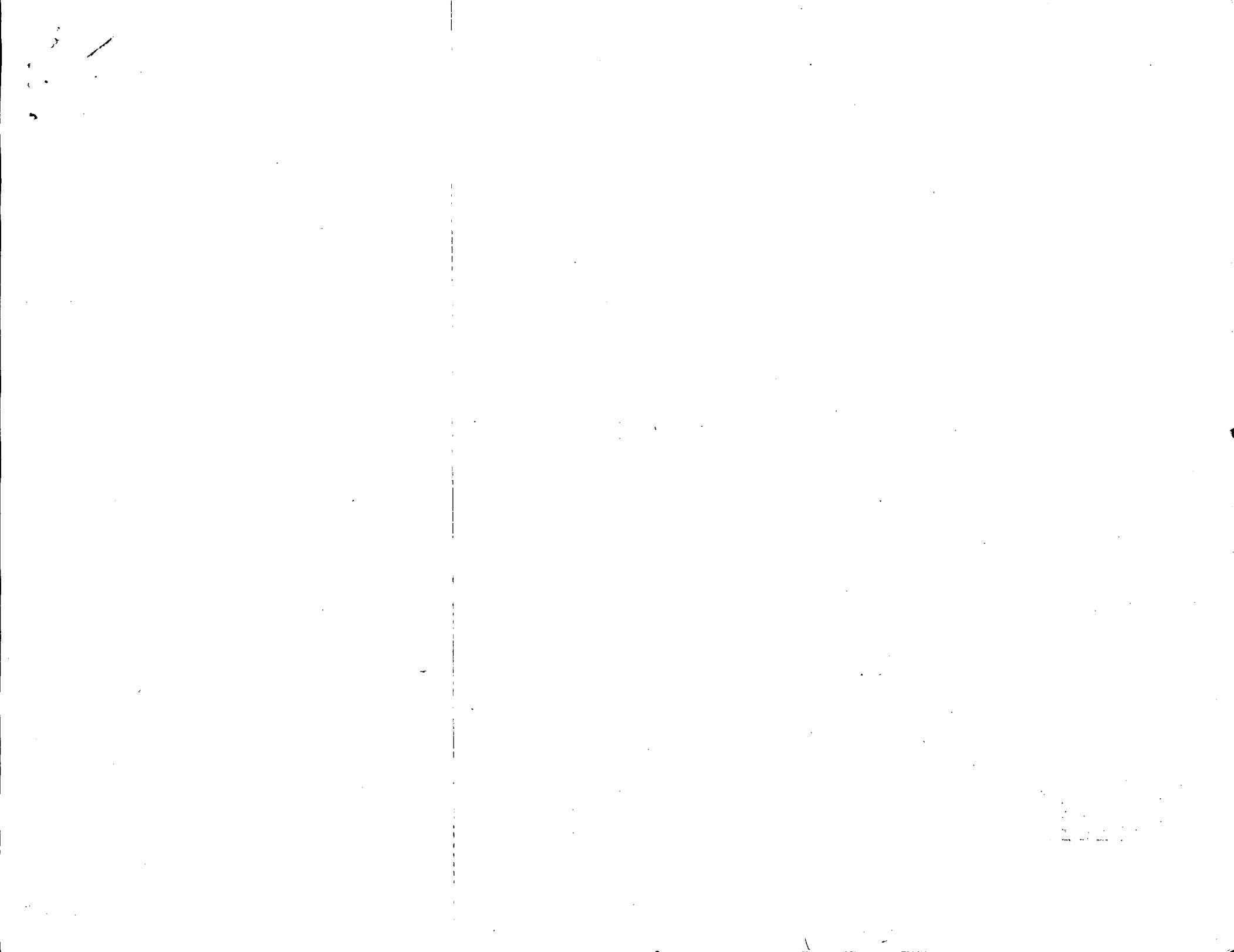
DART AEROSPACE LTD	Work Order:	143567
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.4405	0.4405		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		0.501	0.502	0.503	0.501		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.459	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.568	0.569	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.126	0.128	0.128	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.250	0.250	0.250		
S	0.115	0.135		0.126	0.126	0.126	0.11		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.229	3.230	3.230	3.230		
V	0.230	0.250		0.232	0.232	0.235	0.235		
W	0.115	0.135		0.126	0.129	0.131	0.132		
X	0.307	0.312		0.311					
Y	0.760	0.765		0.760					
Z	0.352	0.372		0.362	0.361	0.361	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.623	0.621	0.622		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		0.242	0.240	0.242	0.2425		
AE	1.500	1.520		1.515	1.517	1.515	1.515		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.280	0.280	0.280	0.280		
AH	0.240	0.260		0.242	0.242	0.246	0.2465		
AI	2.000	2.020		2.007	2.009	2.004	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	DT	Audited by:	JK
Date:	08/12/16	Date:	08/12/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK/JLM



DART AEROSPACE LTD				Work Order:	43567
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

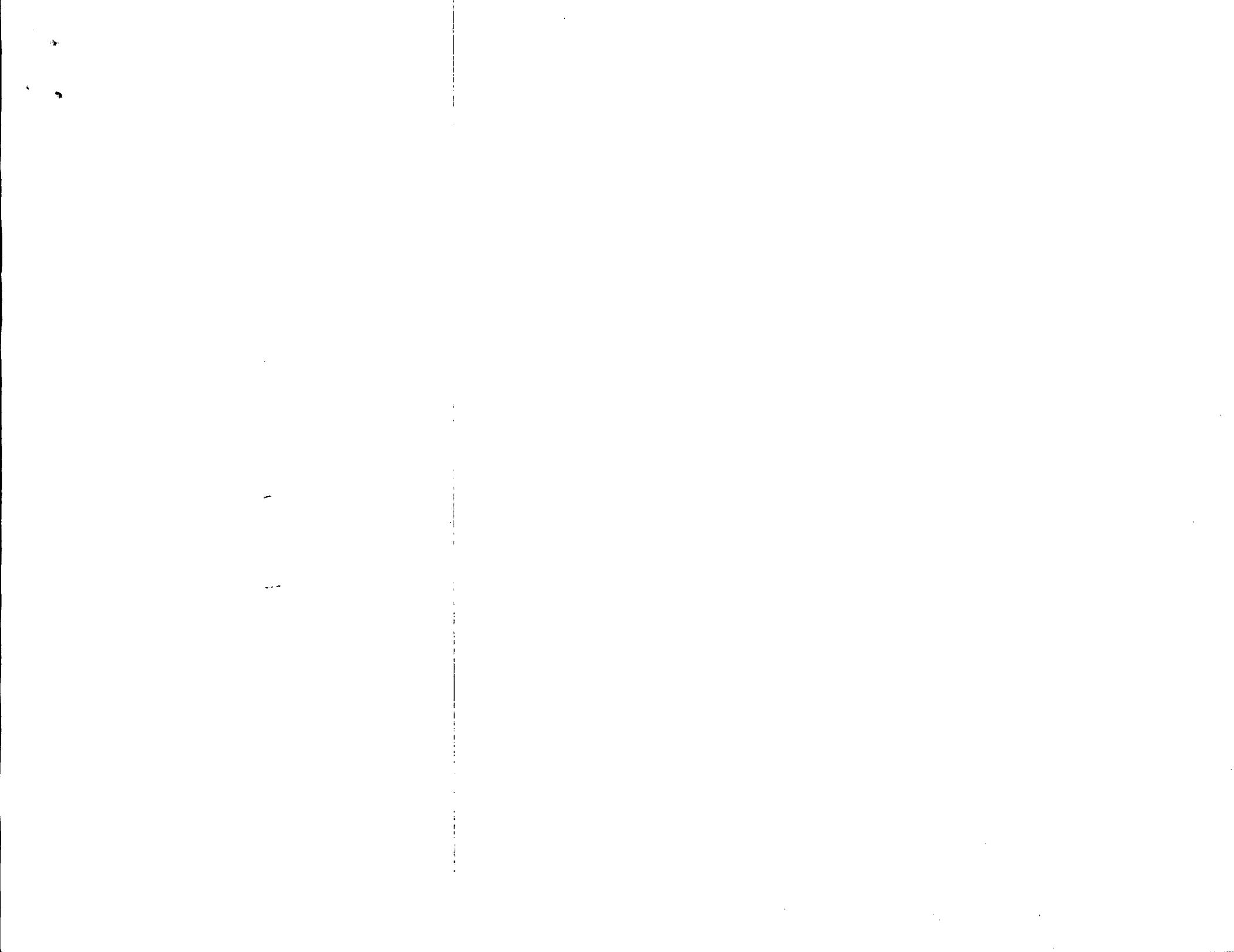
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.005	8.005				
F	0.490	0.510		0.504	0.504				
G	0.257	0.262		0.259	0.259				
H	0.375	0.380		0.377	0.377				
I	0.490	0.510		0.502	0.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.570	0.568				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		0.120	0.127				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.250	0.2505				
S	0.115	0.135		0.131	0.131				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.237	0.235				
W	0.115	0.135		0.133	0.133				
X	0.307	0.312		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.367	0.368				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.622	0.622				
AC	0.053	0.073		0.0625	0.0625				
AD	0.240	0.260		0.242	0.242				
AE	1.500	1.520		1.515	1.511				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.280	0.280				
AH	0.240	0.260		0.246	0.246				
AI	2.000	2.020		2.004	2.004				
AJ	0.023	0.043		0.033	0.033				

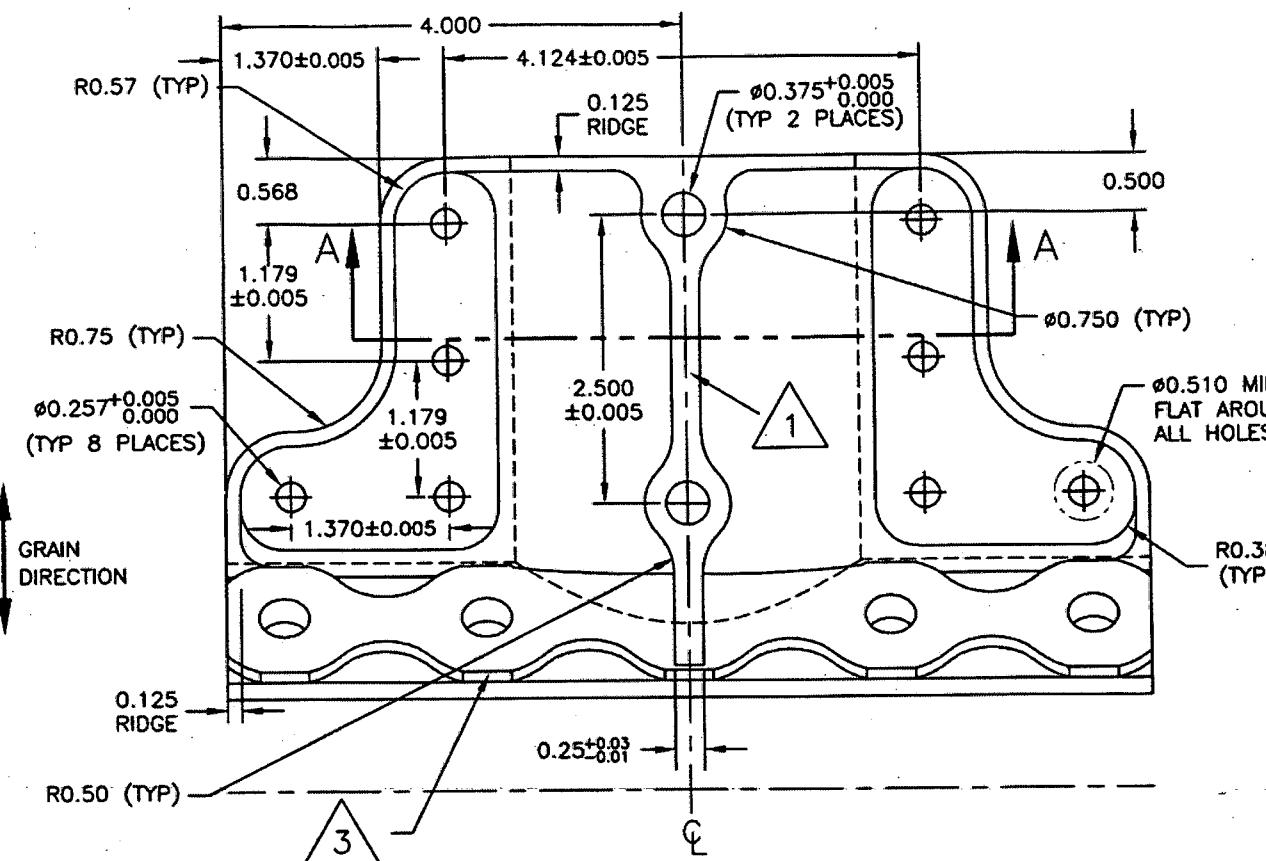
Accept/Reject

Measured by:	DTP
Date:	08/12/07

Audited by:	SD
Date:	08/12/08

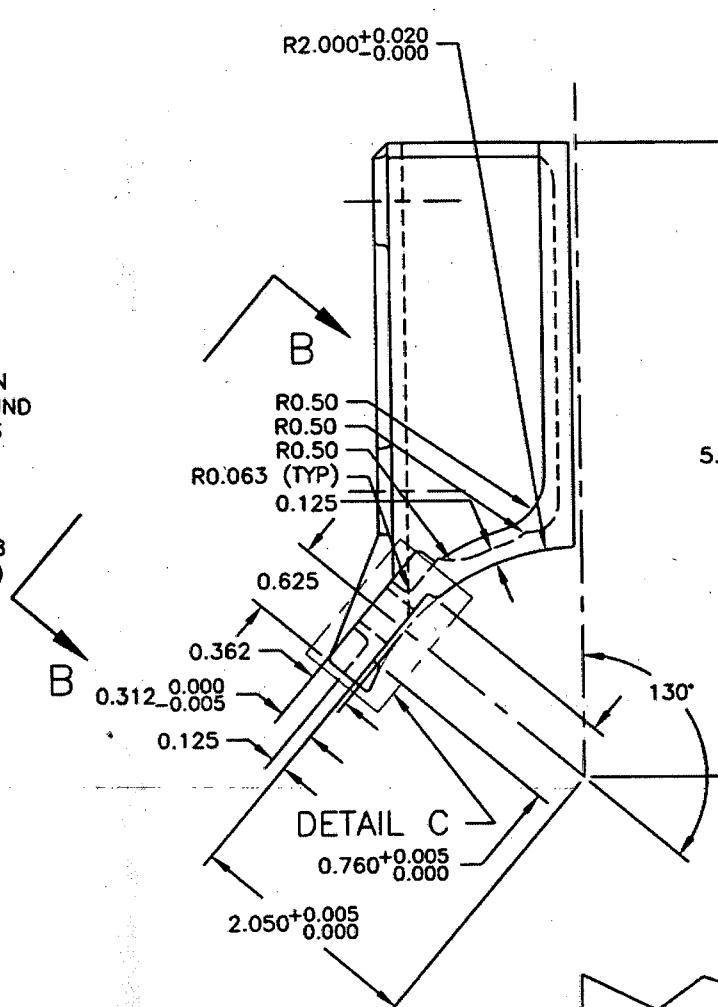
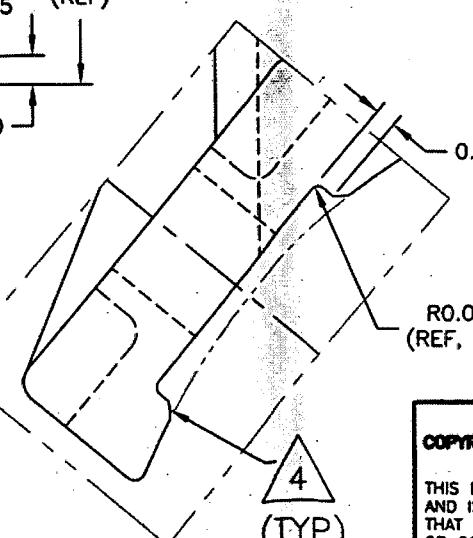
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD





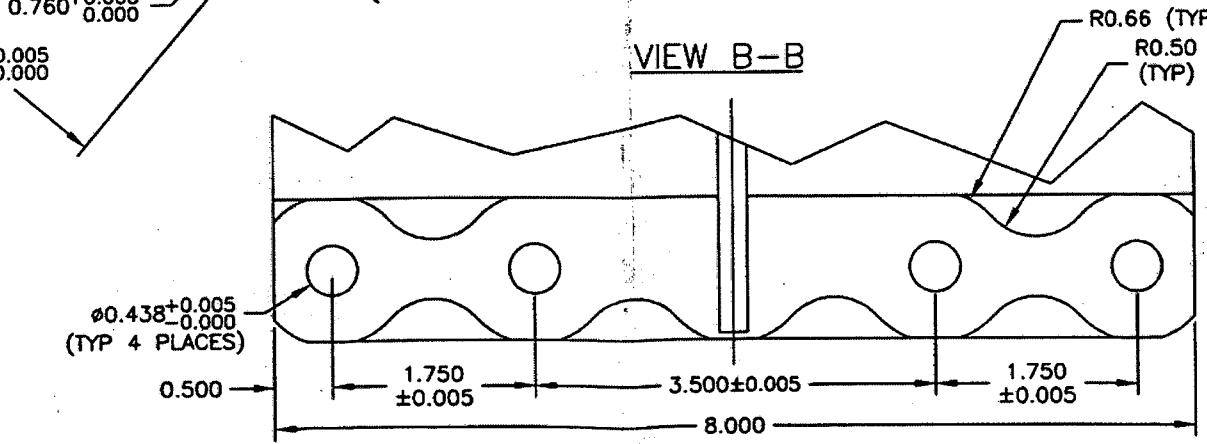
SECTION A-

DETAIL C



DETA

2.050^{+0.0}
-0.0



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENgrave part and batch number in this area to max depth of 0.010

CHAMFER 0.063" x 45° AROUND THIS SURFACE
(TYPICAL 2 PLACES)

CHAMEER 0.063 x 45: ALL AROUND

CHAMFER 0.033 x 45° (SEE DETAIL C)

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

Copyright © 2006 by DART Aerospace Ltd.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	SHOP COPY
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2574	REVISION SHEET	RETURN TO ENGINEERING
DATE 05.07.13	TITLE INNER AFT SADDLE		UNCONTROLLED COPY	SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
No. 4556

